

Date: Tuesday, 12/5/2006 8:21:00 AM
 User: Kim Johnston

Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services		Drawing Name	: LUG		
Job Number	: 29831					
Estimate Number	: 10337					
P.O. Number	: N/A			Part Number	: D28073	
This Issue	: 12/5/2006 S.O. No. : N/A			Drawing Number	: D2807 REV C	
Prsht Rev.	: NC			Project Number	: N/A	
First Issue	: N/A			Drawing Revision	: C	
Previous Run	: 28489			Material	: N/A	
Written By	: <u>KJ</u> 06/12/05			Due Date	: 1/5/2007	
Checked & Approved By	: _____			Qty:	80 Um: Each	
Comment	: Est A 05.06.02 New Issue KJ/JLM					

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :	
1.0	M303R0750	303 Round Bar .75"	
		Comment: Qty.: 0.1094 f(s)/Unit Total : 8.7528 f(s) Material: 303 Round Bar Ø0.750" (M303R0.750)	Batch: <u>102318</u>
2.0	HARDINGE	HARDINGE CNC LATHE SMALL	
		Comment: HARDINGE Turn as per Folio FA529 and Dwg D2807 Dwg Rev: <u>C</u>	<u>8.4 06/12/19</u>
		2-Deburr	
3.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE	
		Comment: INSPECT PARTS AS THEY COME OFF MACHINE	<u>8.4 06/12/19</u>
4.0	HAAS1	HAAS CNC VERTICAL MACHINING #1	
		Comment: Haas #1 Machine as per Folio FA528 and Dwg D2807 Dwg Rev: <u>C</u> Folio Rev: <u>AA</u>	<u>132</u>
		2-Deburr	
5.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE	
		Comment: INSPECT PARTS AS THEY COME OFF MACHINE	<u>J.F. 07/03/10</u> <u>137</u>

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: Date: 07/03/13
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Seq. #:	Machine Or Operation:	Description :
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6.0	QC8	SECOND CHECK
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Comment: SECOND CHECK

07/03/11

7.0	PACKAGING 1	PACKAGING RESOURCE #1
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Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: 0

07/13/12 137

8.0	QC21	FINAL INSPECTION/W/O RELEASE
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Comment: FINAL INSPECTION/W/O RELEASE

07/03/13

Job Completion



07/03/13

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

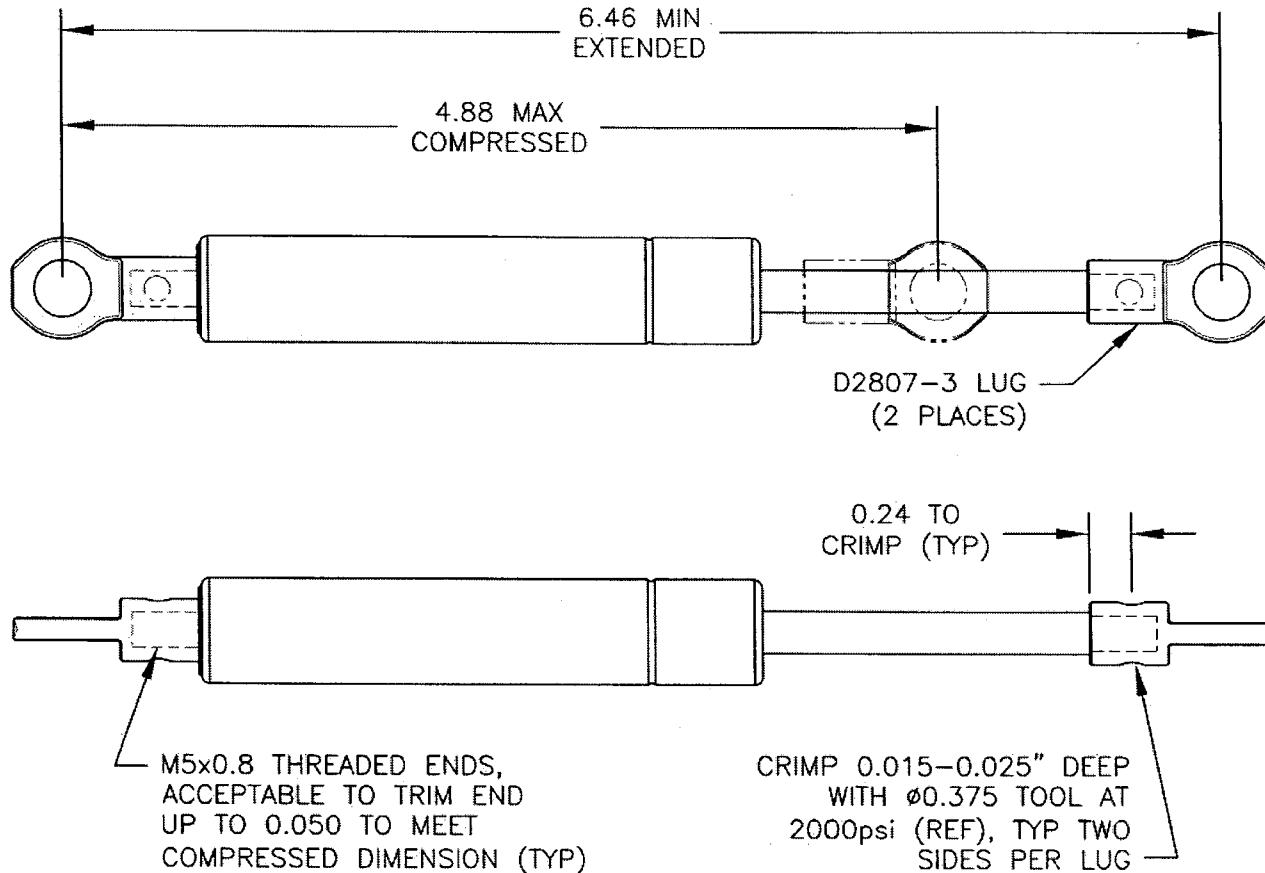
DART AEROSPACE LTD	Work Order:	29831
Description: Lug	Part Number:	D2807-3
Inspection Dwg: D2807 Rev: C		Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

X First Article Prototype

Measured by:	<u>JF / J.F.</u>	Audited by:	<u> </u>	Prototype Approval:	N/A
Date:	<u>06/12/19</u>	Date:	<u>27/03/10</u>	Date:	N/A

Rev	Date	Change	Revised by	Approved
A	06.08.29	New Issue	KJ/JLM	SJL



D2807 GAS SPRING

SPECIFICATION: SS GAS SPRING
ACCEPTABLE LOAD RANGE IS 25 lb MIN TO 45 lb MAX
M5x0.8 THREADS

MANUFACTURER: ArvinMeritor Motion Control Systems, Leicester, UK
P/N: SXF6S6050080S6L-115N
(REF: 80mm LONG CYLINDER, 50mm STROKE, 115N LOAD)

- 1) NO 29831
2) SHORT COPY
3) ALL DIMENSIONS ARE IN INCHES
4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

RETURN TO
ENGINEERING
CONTROLLLED CO
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER

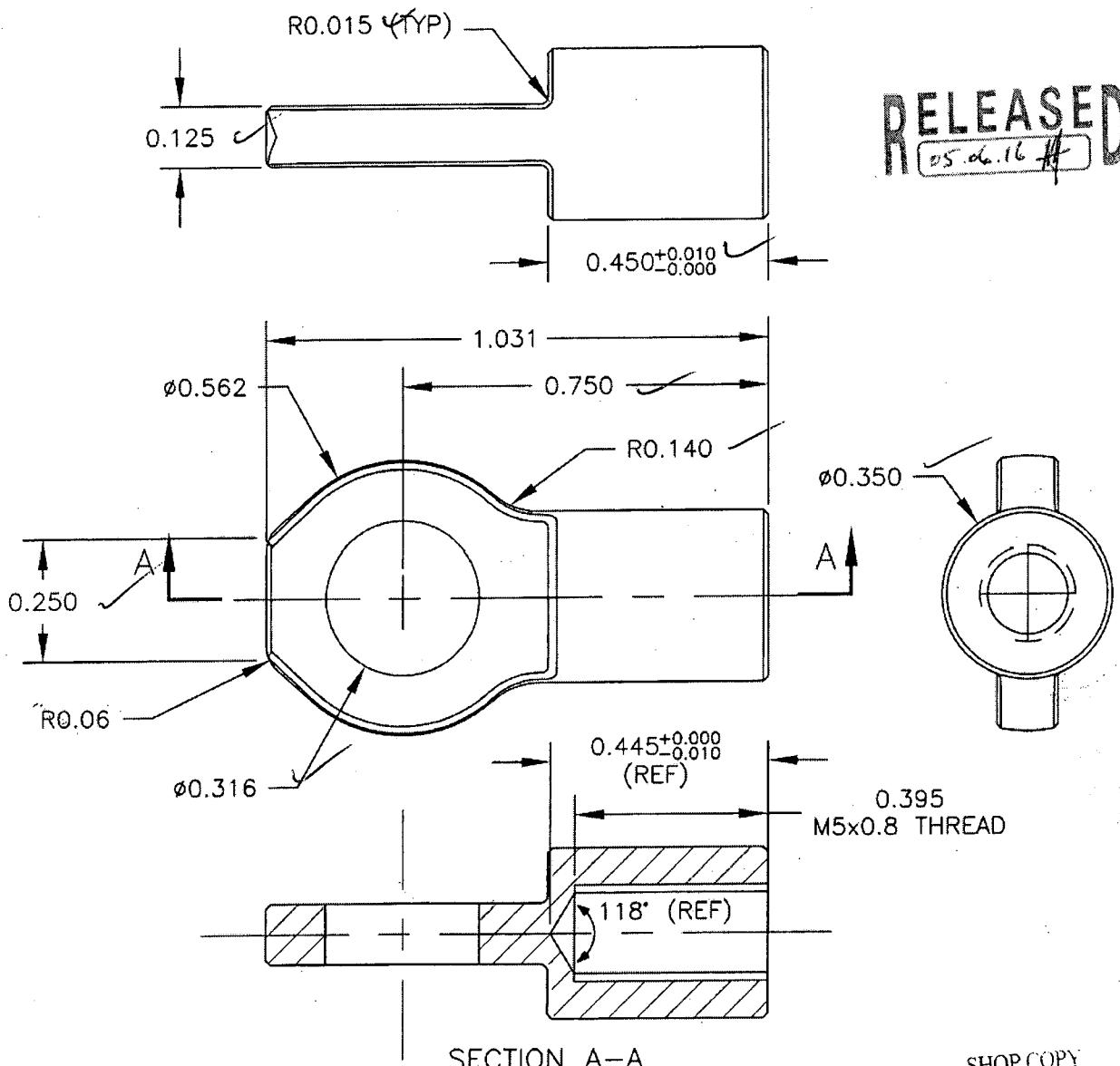
RELEASED
05.06.16

DART

DESIGN CP	DRAWN BY CP	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA
CHECKED	APPROVED	DRAWING NO. D2807
DATE 05.05.25	TITLE	SHEET 1 OF 2
A 00.11.03	NEW ISSUE	1:1
B 05.03.16	ADD FINISH	SCALE
C 05.05.25	CHANGE SPRING TO SS, ADD -3 LUG	

DART

DESIGN CP	DRAWN BY CP	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>[initials]</i>	APPROVED <i>[initials]</i>	DRAWING NO. D2807	REV. C SHEET 2 OF 2
DATE 05.05.25		TITLE GAS SPRING	SCALE 3:1

**D2807-3 LUG**

- 1) MATERIAL: AISI 303 ROUND BAR (REF DART SPEC. M303R)
- 2) FINISH: NONE
- 3) BREAK ALL SHARP EDGES 0.010 TO 0.015
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) ALL DIMENSIONS ARE IN INCHES

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 29831